

**Work Order ID 76745****\*76745\***

Page 1

Monday, November 21, 2011 10:18:34 AM

Item ID: D2661-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011 Start Qty: 8.00

**\*8\***

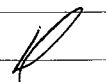
Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: 

Date: 11/21

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2661

Rev E

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number  
MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: AA

DWG REV: E

RQ 11.12.3 8 0

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

RQ 11.12.3

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*76745\***

Monday, November 21, 2011 10:18:34 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 11/21/2011    **Start Qty:** 8.00    **\*8\***

**Cust Item ID:**

**Required Date:** 1/10/2012      **Req'd Qty:** 8.00      **\*Q\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

OC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

29 11.12.3

8

9

QC

## Memo

0.00

## Quality Control

130 QC8- Inspect parts - second check

0.00

**\*130\***

B.A 11/12/04

8

 $\phi$ 

QC

## Memo

0.00

## Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

8X0 m-f 11/12/06

HandFinish

## Memo

0.00

### Hand Finishing

W/O:		WORK ORDER CHANGES					
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**Work Order ID 76745****\*76745\***

Page 3

Monday, November 21, 2011 10:18:34 AM

Item ID: D2661-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, LH Fwd Aft Out 206  
Start Date: 11/21/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 1/10/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 9:30								
	FINISH TIME: 10:00								
	OVEN TEMPERATURE: 320°F								
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC		0.00							
Quality Control	Memo								
170	Identify as per dwg & Stock Location: 435	0.00							
<b>*170*</b>									
Packaging		0.00							
Packaging	Memo								

8x0 M-L 11/12/07

8 BR 11-12-7.

10/11/11 (8)

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 11/21/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 1/10/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

11/12/8 *[Signature]*  
MF  
11-12-07

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, November 21, 2011 10:18:39 AM

Page 1

Work Order ID: 76745

**\*76745\***

Parent Item: D2661-1

**\*D2661-1\***

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house  
processEC IPP REV:D  
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	8			
<b>*D6101-003*</b>									<b>**</b>				
Saddle Billet, 7075													

Re 11.12.3

Location	Loc Qty	Loc Code
MAT040	105	
72226	8	
73775	36	
73780	7	
74650 ✓	54	
MAT44	29	
72226	2	
73769	1	
74680	26	

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 76745
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2661-1
<b>Inspection Dwg:</b> D2661 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	.120	.120	.121	.121	.121	.121	.121
B	0.100	0.140	.116	.116	.120	.120	.120	.120	.120
C	1.125	1.145	1.137	1.137	1.136	1.138	1.138	1.138	1.138
D	0.615	0.685	.685	.685	.685	.685	.685	.685	.685
E	0.240	0.260	.242	.242	.247	.247	.247	.247	.247
F	1.313	1.343	1.318	1.318	1.324	1.324	1.324	1.324	1.324
G	0.210	0.230	.215	.215	.220	.221	.221	.221	.221
H	0.100	0.180	.140	.140	.140	.140	.140	.140	.140
I	2.470	2.510	2.490	2.490	2.490	2.490	2.470	2.490	2.490
J	1.565	1.585	1.577	1.577	1.575	1.577	1.577	1.577	1.577
K	0.235	0.240	.237	.237	.237	.237	.237	.237	.237
L	0.100	0.120	.111	.111	.111	.111	.111	.111	.111
M	0.990	1.010	1.000	1.000	1.000	1.000	1.000	1.000	1.000
N	0.510	0.515	.512	.512	.512	.512	.512	.512	.512
O	5.990	6.010	5.998	5.998	5.998	5.998	5.998	5.998	5.998
P	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318	.313	.313	.313	.313	.313	.313	.313
S	0.315	0.322	.316	.316	.316	.316	.316	.316	.316
T	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367	1.362	1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807	.795	.795	.795	.796	.796	.796	.796
W	0.540	0.560	.548	.548	.550	.550	.550	.550	.550
X	1.674	1.684	1.679	1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262	.257	.257	.257	.257	.257	.257	.257
Z	0.912	0.932	.922	.922	.922	.922	.922	.922	.922
AA	0.490	0.510	.499	.499	.499	.499	.499	.499	.499
AB	0.178	0.198	.188	.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: JL	120
Date: 11-12-02	11. 12. 3

Audited by: BA	
Date: 11/12/04	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

W/O:		WORK ORDER CHANGES					
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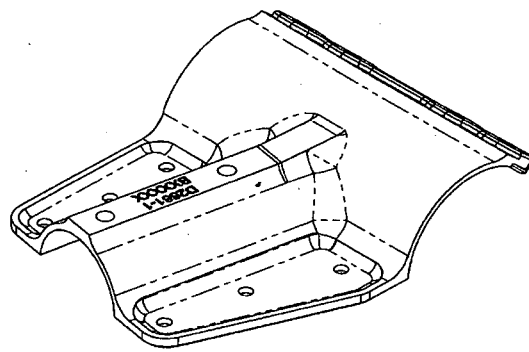
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

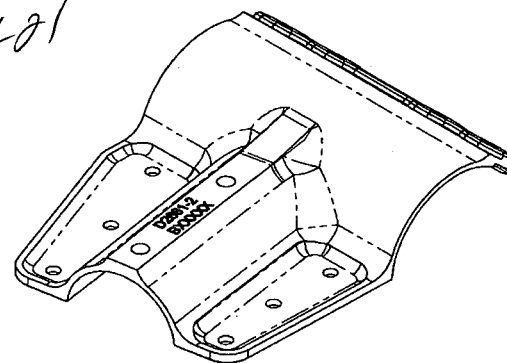
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**NOTE:** Date & initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO THE NEXT  
 WITH THE  
 WORK ORDER  
 NO. 76745  
R111-81



**D2661-1 SADDLE, OUTSIDE, LH**



**D2661-2 SADDLE, OUTSIDE, RH**

**RELEASED**  
 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	08.11.08
C	INCORPORATE DEO 9122, 9102, 9085	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>g</i>	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	<i>g</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DRAWING NO.	REV. E
		D2661	SHEET 1 OF 5
		TITLE	SCALE
		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

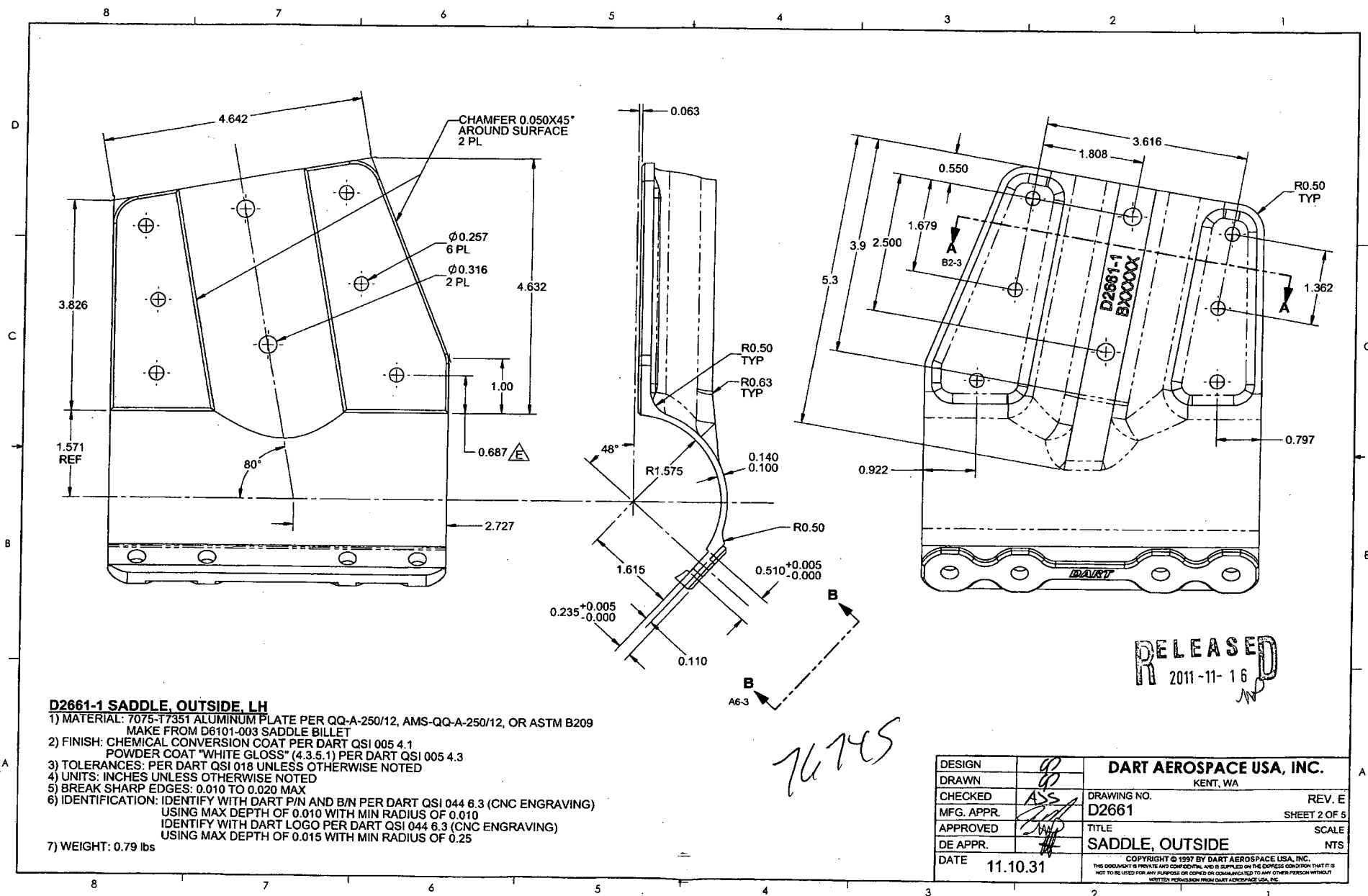
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MFG. APPR.		D2661	SHEET 2 OF 5
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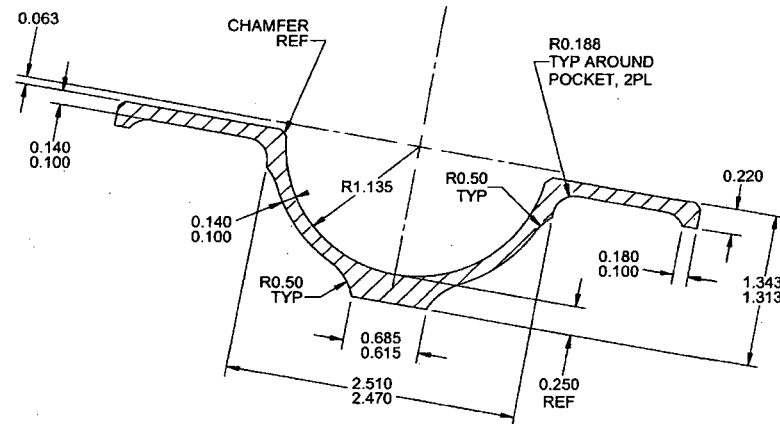
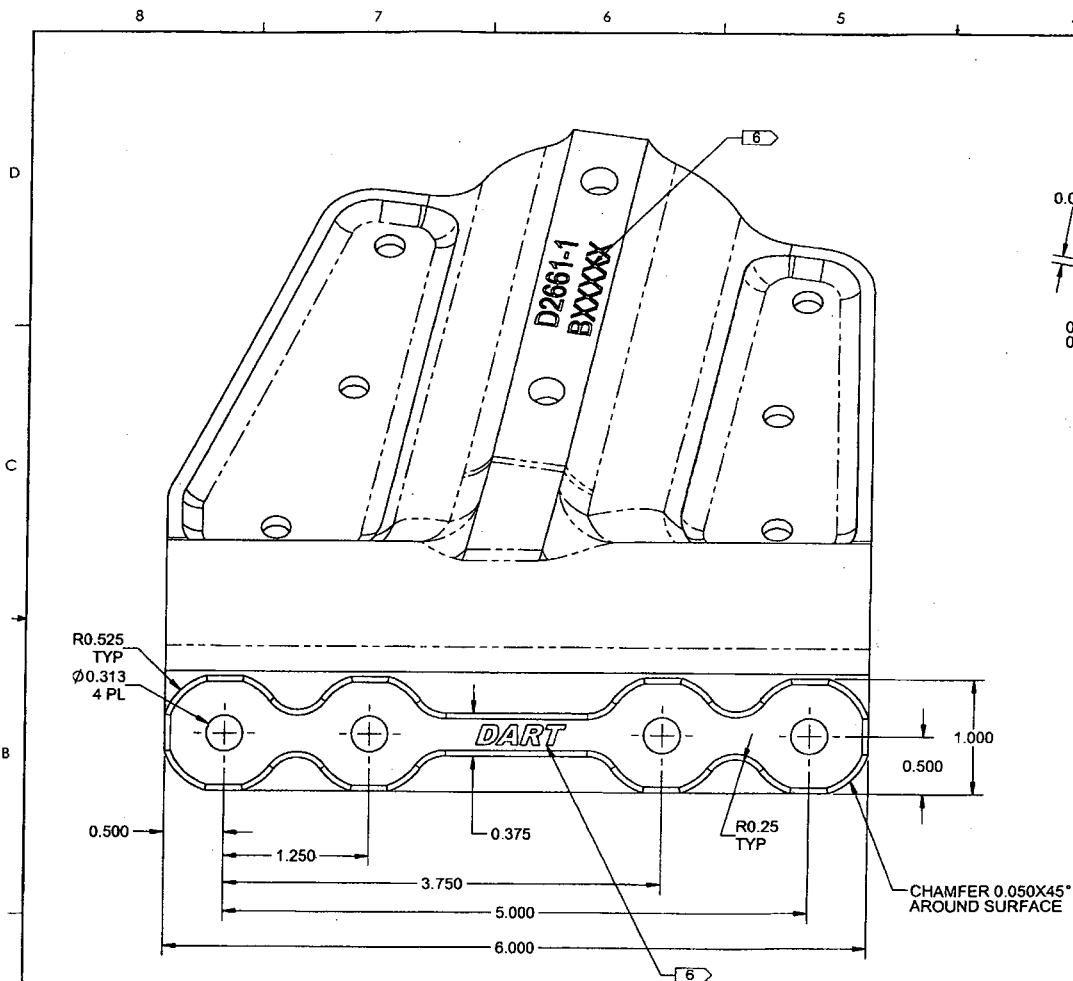
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**VIEW A-A**  
SCALE 1.5X

C3-2

76745

**RELEASED**  
R 2011-11-16

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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED		TITLE	SCALE
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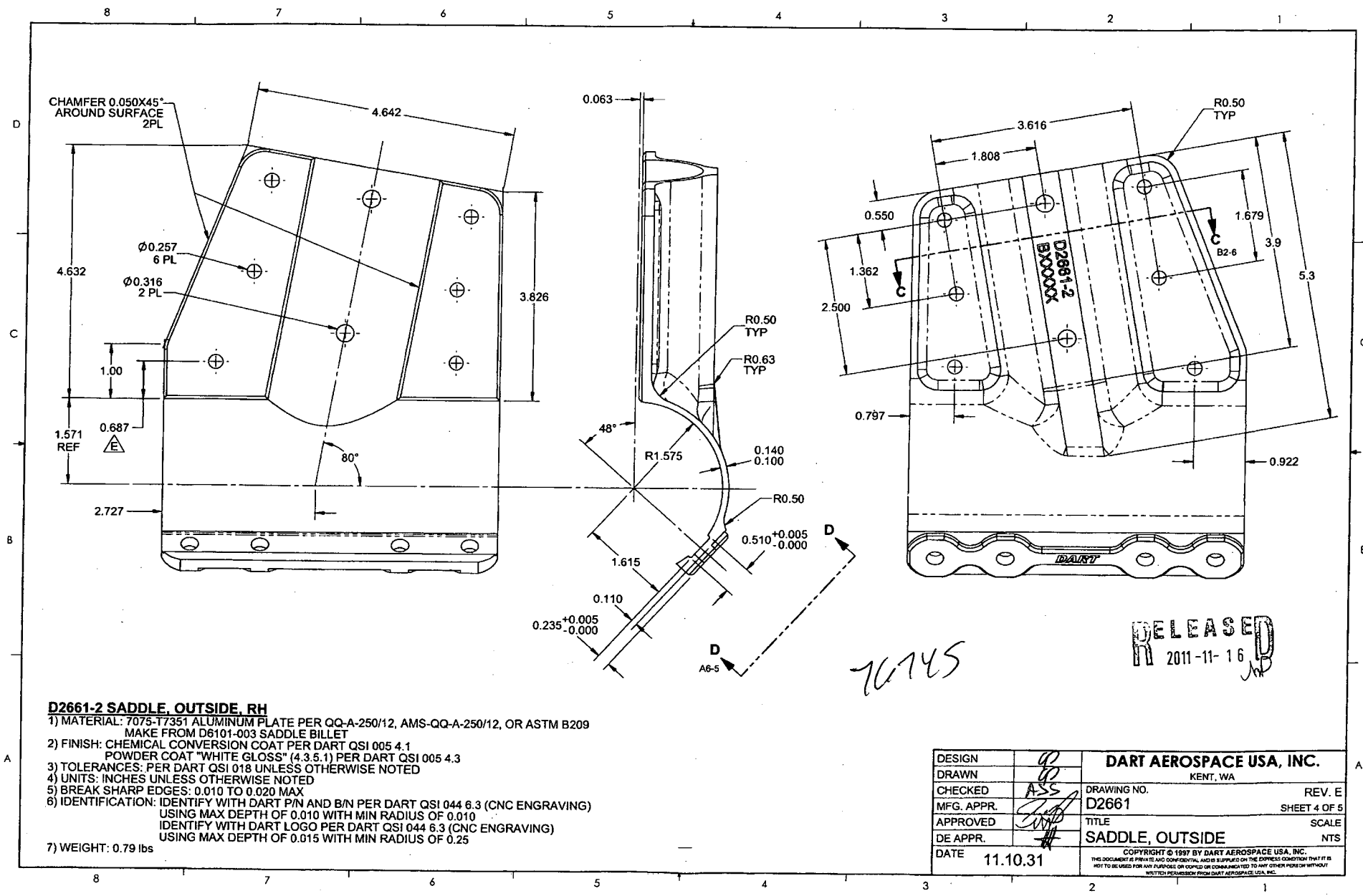
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**D2661-2 SADDLE, OUTSIDE, RH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

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2011-11-16

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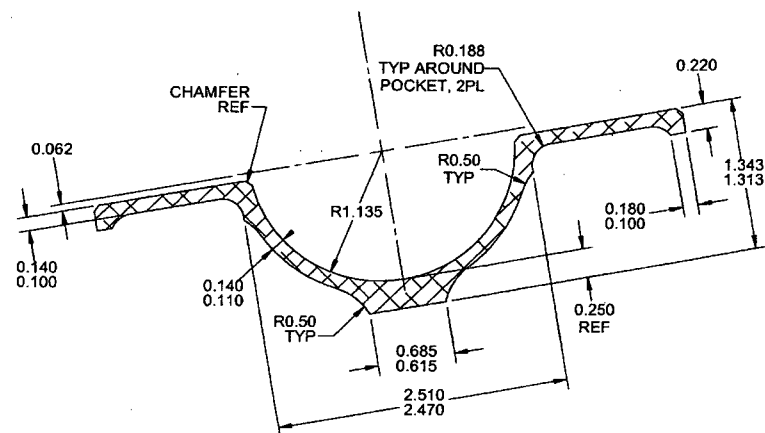
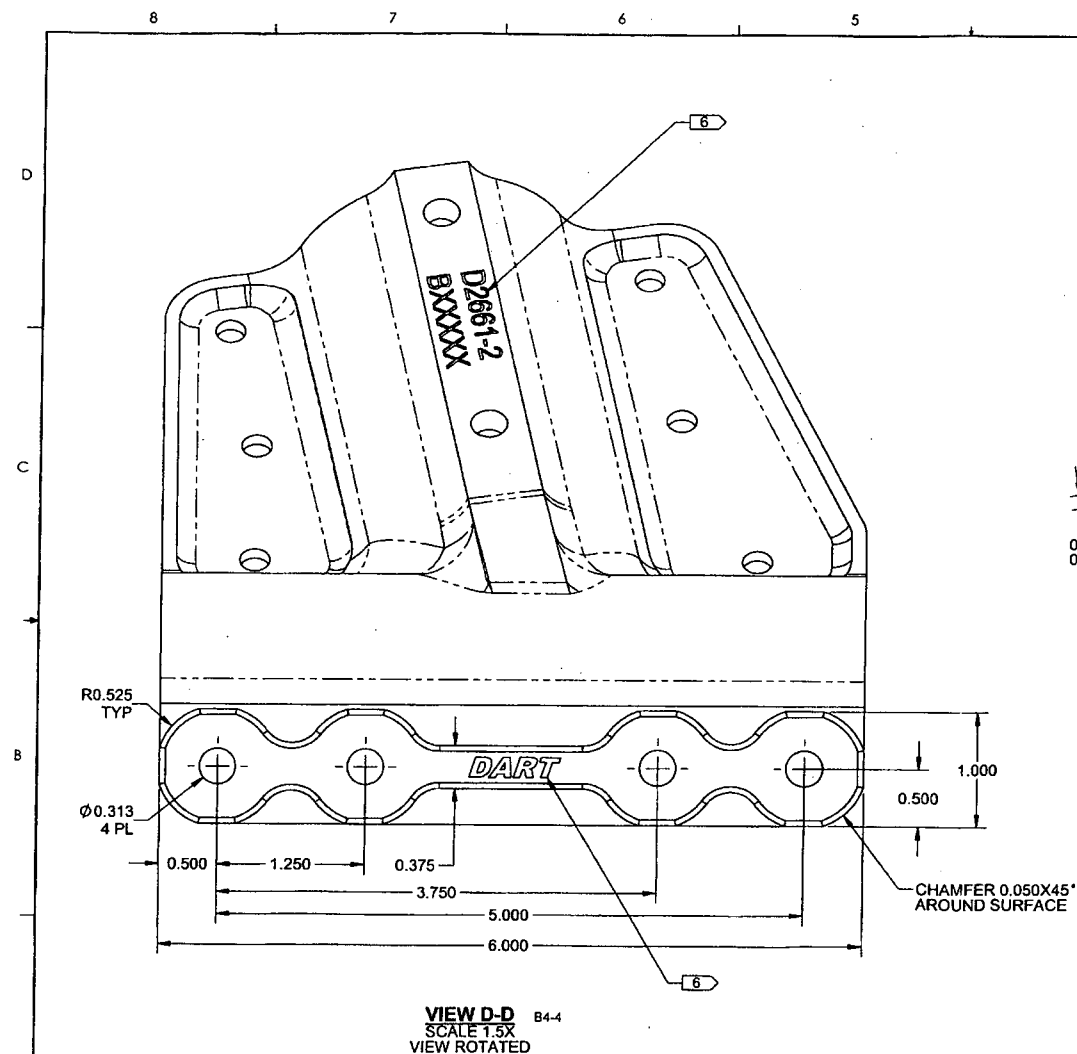
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DRAWN	DP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	DP	D2661	SHEET 5 OF 5
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries